

# Work Order ID 82151

\*82151\*

Page 1

Friday, March 23, 2012 1:24:48 PM

Item ID: D3415-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Nut Plate  
 Start Date: 3/23/2012 Start Qty: 20.00 \*20\* Cust Item ID:  
 Required Date: 3/30/2012 Req'd Qty: 20.00 \*20\* Customer:  
 Reference:

Approvals: Process Plan: [Signature] Date: 12-03-23 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start \*NR1\*  
 Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3415	Rev B								

100 0.00  
 \*100\* FLOW WATER JET  
 Waterjet Memo 0.00  
 FLOW CNC Waterjet 1-Cut as per Dwg D3415 Dwg Rev: B Prog Rev: B 2-  
 304 C.063 Debur if necessary  
 (34) 12-4-21

110 0.00  
 \*110\* QC2- Inspect parts off machine FAI/FAIB  
 QC Memo 0.00  
 Quality Control 12-4-21

120 0.00  
 \*120\* QC8- Inspect parts - second check  
 QC Memo 0.00  
 Quality Control 5/7/12/23  
 (34) 12-4-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 82151**

Friday, March 23, 2012 1:24:48 PM

**\*82151\***

Page 2

Item ID: D3415-041      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Nut Plate  
Start Date: 3/23/2012      Start Qty: 20.00      **\*20\***      Cust Item ID:  
Required Date: 3/30/2012      Req'd Qty: 20.00      **\*20\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00				34x	0		9/2/04/27
Small Fab	1- Deburr 2-C'sink as per Dwg D3415								
140 <b>*140*</b> QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00		8.76/30					carb (x34)
150 <b>*150*</b> Powdercoat	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powder Coating	Memo	0.00							
	START TIME: 2:30								
	FINISH TIME: 4:00 P								
	OVEN TEMPERATURE: 3:00								

M121134

34x ✓ MF 12/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*82151\***

Friday, March 23, 2012 1:24:48 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop **\*NS2\***

**Cust Item ID:**

**\*20\***

**\*20\***

**Customer:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

160

**\*160\***

QC

## Quality Control

QC3- Inspect Part Finish

## Memo

0.00

0.00

34 \$ 1251.

170

**\*170\***

### Small Fab

## Small Fab

## Small Fab

## Memo

0.00

0.00

34  $\emptyset$   12/05/02

180

**\*180\***

QC

## Quality Control

QC5- Inspect part completeness to step on W/O

## Memo

0.00

0.00

Sitzsturz

Conto  
x34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82151

Friday, March 23, 2012 1:24:48 PM

**\*82151\***

Page 4

Item ID: D3415-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Nut Plate  
 Start Date: 3/23/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 3/30/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>42</u>	0.00							
<b>*190*</b>									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									

340 125138  
12/5/3  
 M65 12/05/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Friday, March 23, 2012 1:24:52 PM

**\*82151\***

**\*D3415-041\***

**Start Date:** 3/23/2012**Required Date:** 3/30/2012**Start Qty: 20.00**

**Required Qty: 20.00**

**Comments:** IPP: A05.10.03New issueKJ/JLM  
IPP Rev:B Now on Waterjet 07-03-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20613-3C3		Purchased	No			100	Each	214.0000	2	40			
<p><b>*MS20613-3C3*</b></p> <p>RIVET 427 M 3-3</p> <p>Retail: Holes are correct. 1205.02 @ 51042</p>													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST322				214					
				105408				20					
				17654				194					
M304S16GA		Purchased	No			170	sf	419.5060	0.0131	0.275789			
<p><b>*M304S16GA*</b></p> <p>304/316 Sheet .063</p>													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT020				419.506					
				119653				0.35					
				120866				72.5					
				120877				154.656					
				121070				192					
MS21070L4		Purchased	No			170	Each	281.0000	1	20			
<p><b>*MS21070L 4*</b></p> <p>Inventory</p>													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST302				281					
				105878				281					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

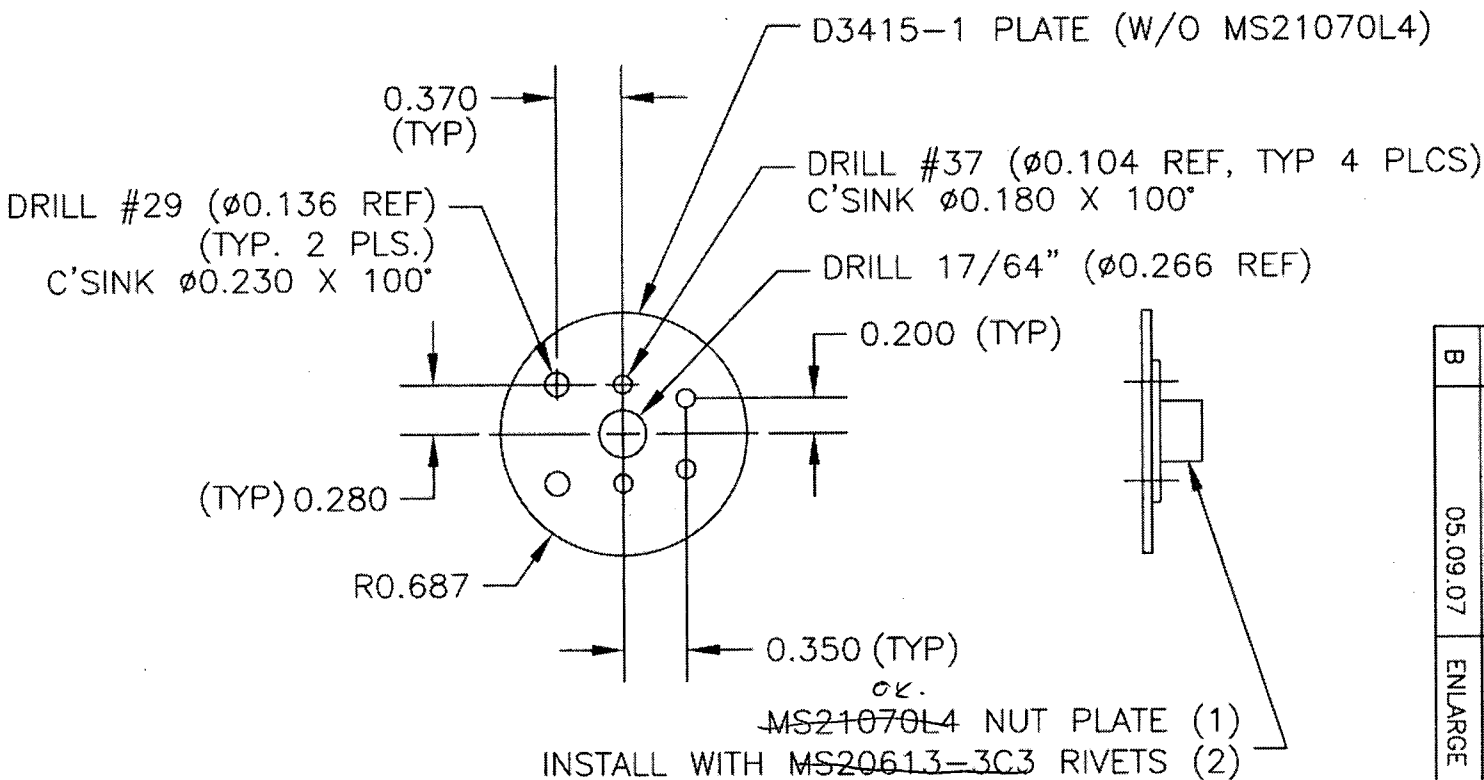
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CP	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
#	#	D3415
DATE	TITLE	SHEET 1 OF 1
05.09.07	NUT PLATE	SCALE
A	05.03.16	1:1
B	05.09.07	
	NEW ISSUE	
	ENLARGE ALL HOLES FOR POWDER COAT	



### D3415-041 NUT PLATE

- 1) MATERIAL: AISI 304 SS SHEET, 0.063 THICK  
(16 GAUGE, REF DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 82151

12/03-23

RELEASED  
05.09.09-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries